

Work Order ID 66251-2

February 8, 2011 10:05:45 AM



Page 1

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 2/08/11

Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/11

Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/02/08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2938

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

Work Order ID 66251

February 8, 2011 10:05:45 AM



Page 2

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 2/08/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:05 OVEN TEMPERATURE: 325 FINISH TIME: 2:35

OK 11/03/04

1 2

1 BK 11-3-7

1 BK 11-3-7

Work Order ID 66251

February 8, 2011 10:05:45 AM



Page 3

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Item Name: Saddle LH Out, 206

Stop



Start Date: 2/08/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 11/03/07

170

Identify as per dwg & Stock Location: 428A

0.00



Packaging

Memo

0.00

Packaging

11/3/8 5/10

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/08

CZ 11/03/08

Picklist Print

February 8, 2011 10:05:44 AM

Page 1

Work Order ID: 66251

Parent Item: D2938-1

Parent Item Name: Saddle LH Out, 206




Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003  Saddle Billet, 7075		Manufactured	No			100	Each	30.0000	1	6		11-3-1	

Location

Loc Qty

Loc Code

MAT

20

65151

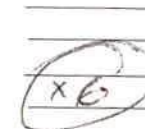
20

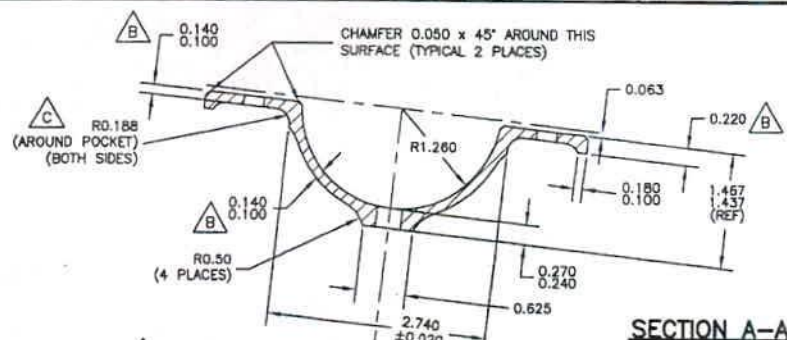
MAT042

10

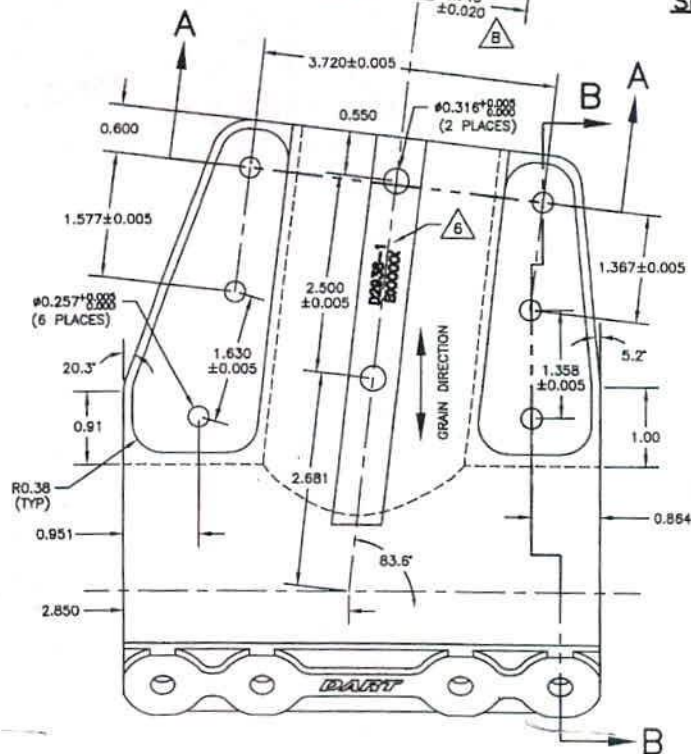
65175

10





SECTION A-A



ENGRAVE DART LOGO TO MAX DEPTH
OF 0.005 WITH MIN RAD 0.250

#0.312 ± 0.003
(4 PLACES)

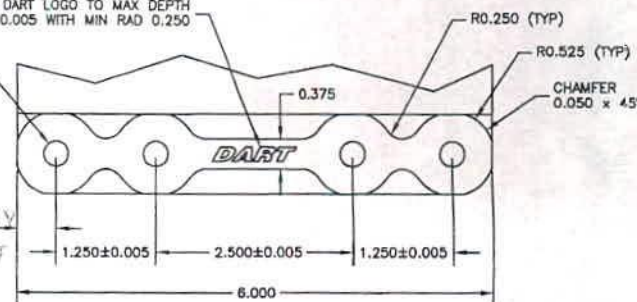
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RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

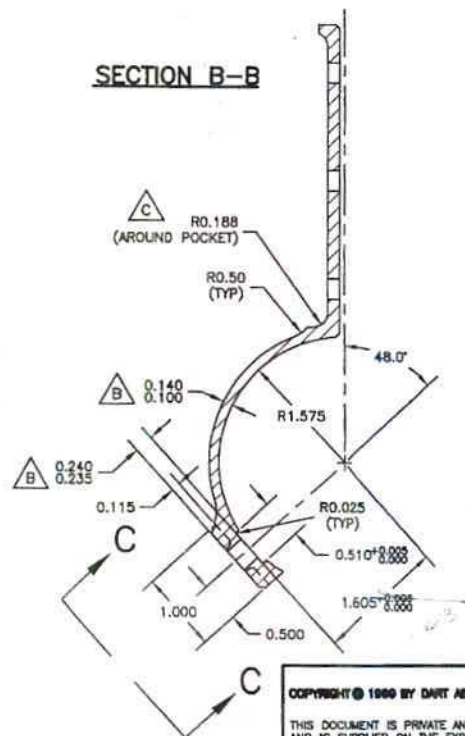
NO. 66251

C 21102108



VIEW C-C

SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	D2938
DATE	TITLE	SADDLE OUTSIDE
06.11.09		

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DART AEROSPACE USA, INC.

REV. C
SHEET 1 OF 1

SCALE
2:3

07.02.12

DART AEROSPACE LTD	Work Order:	46251
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.127	.128				
B	0.100	0.140		.127	.130				
C	0.100	0.140		.135	.135				
D	0.210	0.230		.222	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.112	.111				
O	0.540	0.560		.548	.549				
P	0.490	0.510		.495	.496				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.742	2.742				
S	0.240	0.270		.250	.252				
T	0.100	0.180		.127	.127				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.314	.316				
X	1.250	1.270		1.262	1.261				
Y	1.565	1.585		1.574	1.573				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	11.3.1

Audited by:	<i>[Signature]</i>
Date:	11/03/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 44251
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.128	.117	.127	.130		
B	0.100	0.140		.119	.110	.127	.125		
C	0.100	0.140		.135	.121	.135	.128		
D	0.210	0.230		.224	.224	.222	.228		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.312	.313	.313	.313		
M	0.235	0.240		.237	.238	.238	.238		
N	0.100	0.140		.113	.128	.128	.113		
O	0.540	0.560		.548	.548	.548	.550		
P	0.490	0.510		.505	.501	.501	.495		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.744	2.742	2.742	2.742		
S	0.240	0.270		.251	.235 *	.250	.251		
T	0.100	0.180		.127	.127	.127	.127		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.368	1.367	1.367	1.367		
W	0.316	0.321		.316	.315	.316	.316		
X	1.250	1.270		1.263	1.278 *	1.262	1.263		
Y	1.565	1.585		1.578	1.588 *	1.575	1.572		
Z	0.178	0.198		.185	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

RQ-02

RQ-06
RQ-02

RQ-09
RQ-09

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 11.3.1	Date: 11/03/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2938-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>66251-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.1.04		DIMENSIONS .063" AND .270 / .240" HIGHLIGHTED IN DRAWING ARE .008" AND .005" UNDER TOLERANCE RESPECTIVELY. OFFSET ENTRY ERROR, OFFSET ENTERED TO LATE FOR CONTROL TO READ OPERATOR ERROR SPINDLE #2.	CP 11.03.04 DS/ML	Acceptable. MARGIN OF SAFETY FROM SR-D206-642 = 1.2 IN BEARING OF XTUBE HOLES. 0.005 WILL NOT HAVE SIGNIFICANT EFFECT	11.1.04	OK 11/03/04	CP 11.03.04 DS/ML	S 11/03/04

NOTE: Date & initial all entries